

Date: Thursday, 3/13/2008 10:19:38 AM  
 \*User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37925C		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 37452C	Material	:
Written By	:	Due Date	: 3/28/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>HB 080313</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.5435 sf(s)

Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick

(M2024T3S.040)

Identify as D2279

Batch: 107461

**MAT NOT REMOVED**  
**HB 8-3-25**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D 2279

Dwg Rev: DProg Rev: D

**HB 8-3-25**

2-Deburr if necessary

**HB 8-3-25**

(19)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

**HB 8-3-25**

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

**HB 08/03/25**

(19)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form As per Dwg D2279

**HB 08/03/25**

(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: STEP SPACER

Job Number: 37925C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 (19)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/03/27 (19)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-27 (19)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 54112

08/3/28 19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/03

Job Completion



mf 08-03-28  
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

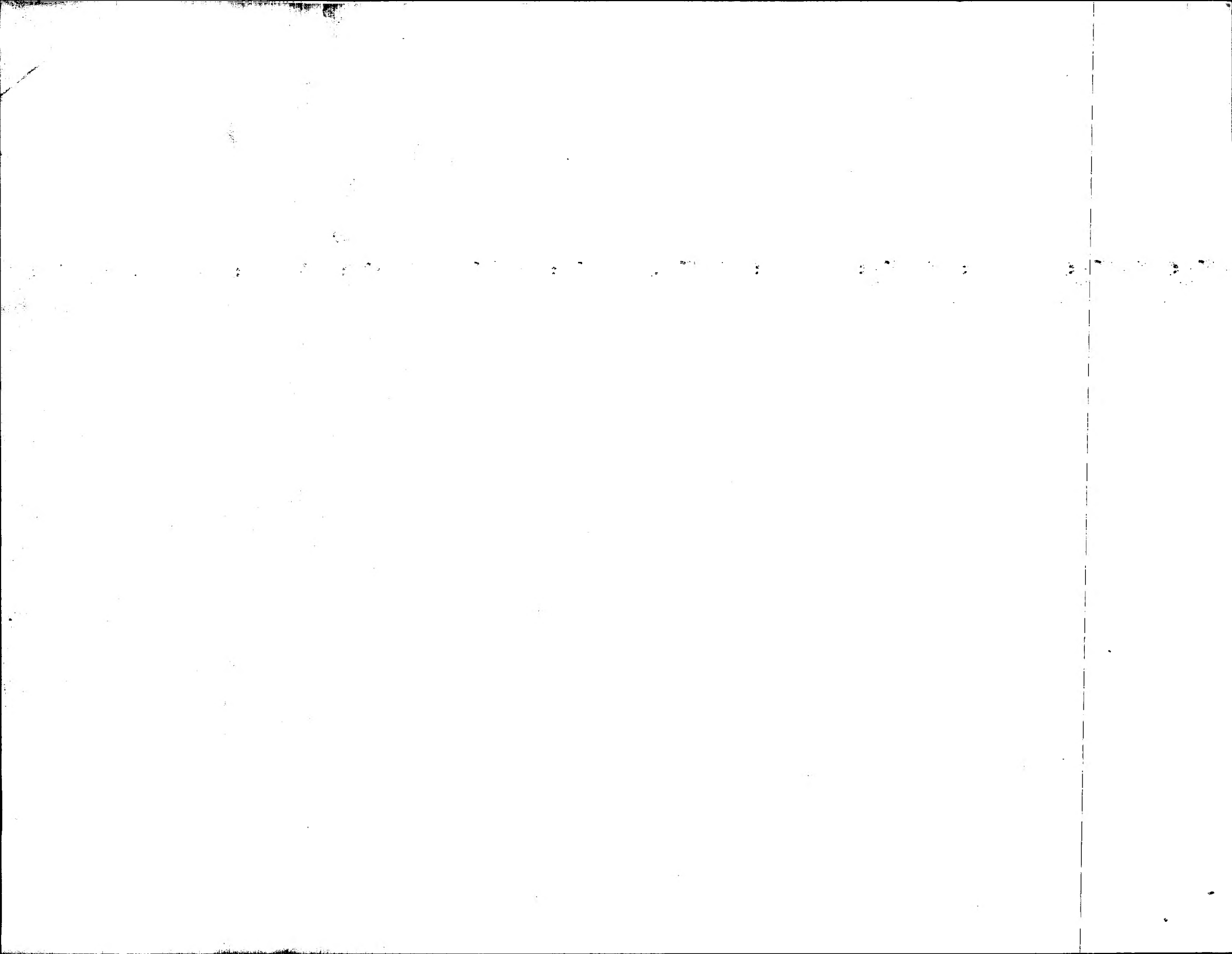
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

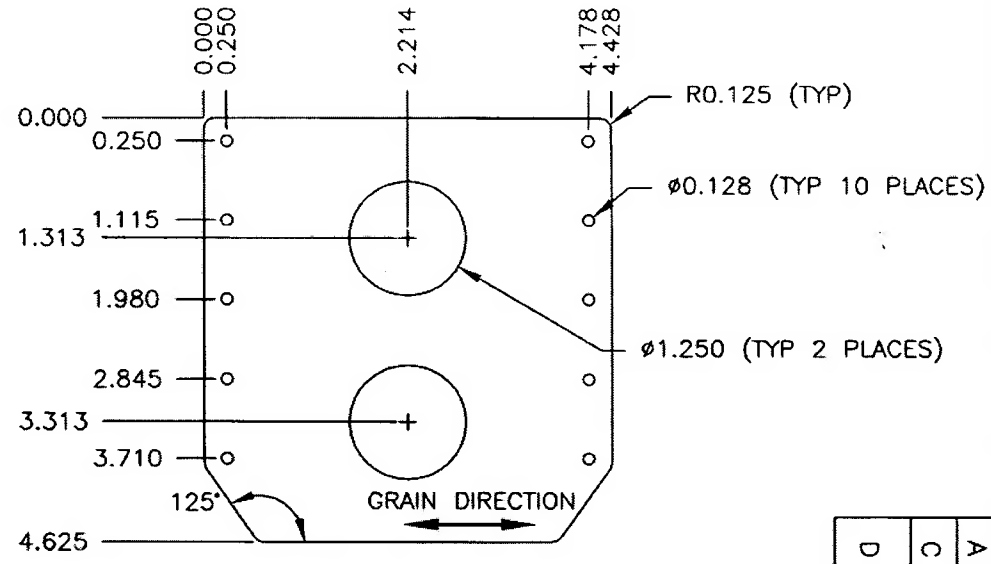
NOTE: Date & initial all entries





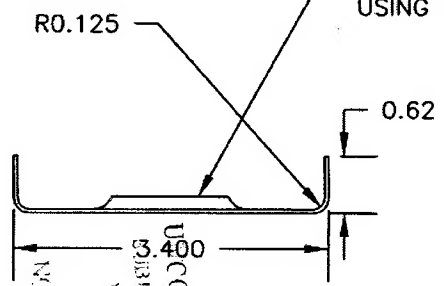
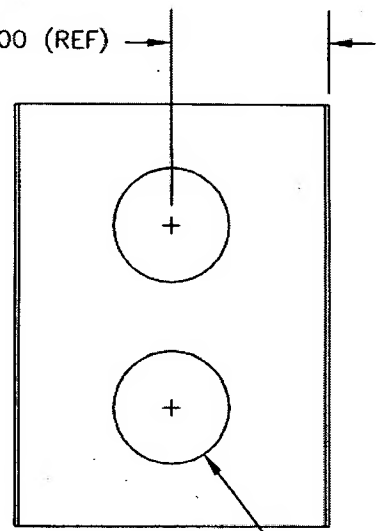
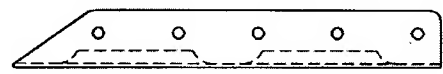


DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		JP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	JP	DRAWING NO.	REV. D
DATE		TITLE		SHEET 1 OF 1	
98.10.05		STEP SPACER		SCALE	
A		94.10.13		NEW ISSUE	
C		94.11.15		0.588 WAS 1.607 AND 3.861 WAS 4.881	
D		98.10.05		4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)



SHOP COPY  
RETURN TO  
ENGINEERING  
DEPARTMENT  
SUBJECT TO APPROVAL  
DATE: 3/19/05  
BY: 37925c

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
98.10.08 DS

UNDER REVIEW  
98.10.15 JP

DESIGN OK, BUT CHECK WITH  
TSR BEFORE MANUFACTURE  
OK 9/19/05